Work Order ID 116540

April-17-14 7:56:19 AM

116540

Item ID: D4871-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: End Fitting

Start Date: 4/17/14 **Start Qty:** 8.00 *8*

Required Date: 5/02/14 **Req'd Qty:** 8.00 *8*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** MLS **Date:** 14-04-17 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**									
D4871 / Rev A									
100		0.00							
100						CZ 14/04/17		8	
Outsource5	**Memo**	0.00							
Outsource process - Machining	ISSUE P/O: 23860 POSSIBLE SUPPLIER:ATG C OF C IS REQUIRED								
110	QC6- Inspect dimensions to drawing	0.00 DAS 27 9-89							
110						8			
QC	**Memo**	0.00 M/6/9							
Quality Control									
150		0.00							
150	PURCHASING					CZ 14/05/09			
Purchasing	**Memo**	0.00 done ATG N/A							
Purchasing	Issue P/O: 23860 LPI Per ASTM 1417 LEVEL 2 Certificate of conformaty is required								

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Work Order ID 116540

116540

April-17-14 7:56:19 AM

Item ID: D4871-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: End Fitting

Start Date: 4/17/14 **Start Qty:** 8.00 *8*

Required Date: 5/02/14 **Req'd Qty:** 8.00 *8*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Receive & Inspect for Damage & Mat'l Certs	0.00				8			
160									
Packaging	**Memo**	0.00							
Packaging	Ensure certificate of conformity is attached								
	identify : ST 124					8X		DAS 28 9-89	JUN 09 2014
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	**Memo**	0.00							
Quality Control						MLJ	14-06-10		
									MF 14-06-10

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

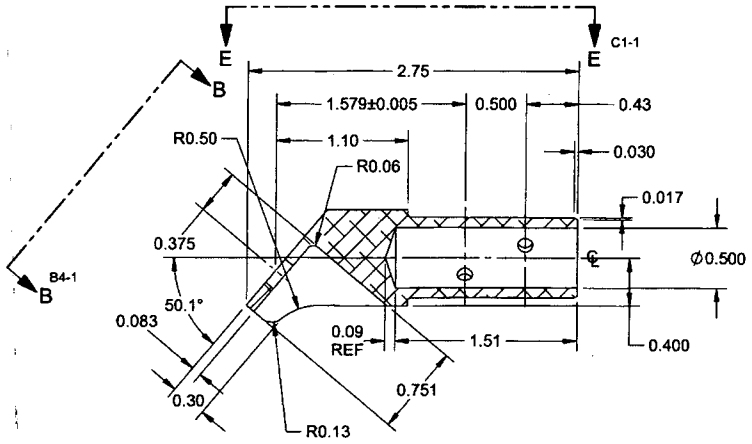
FAULT CATEGORY

Landing Gear

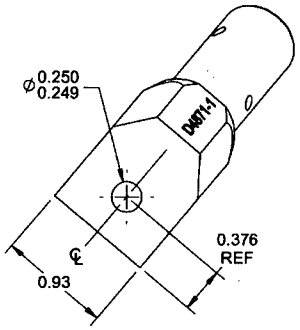
☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

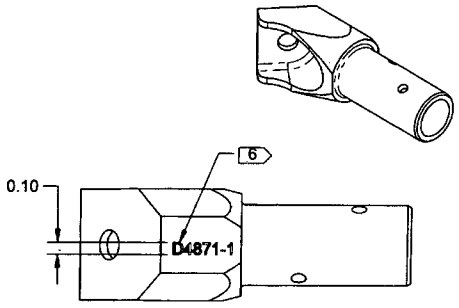
☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other



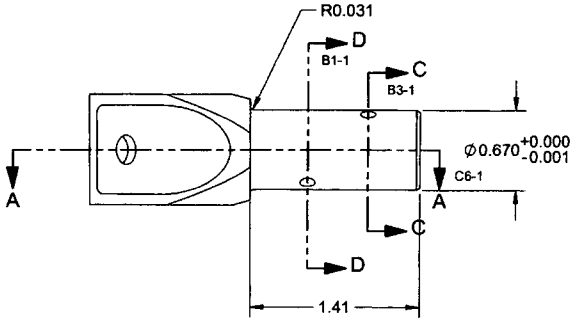
SECTION A-A B6-1

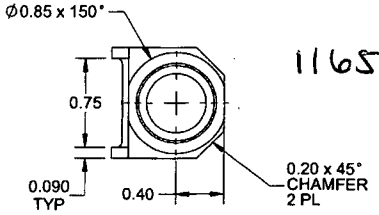


AUXILIARY VIEW B-B D8-1

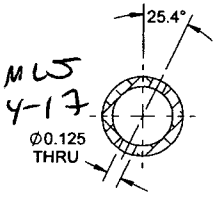


AUXILIARY VIEW E-E D6-1

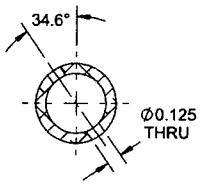




116540 MLS
1404-17



SECTION C-C B6-1



SECTION D-D B6-1

D4871-1 END FITTING

RECEIVED
DEC 2013 -12- 12

NOTES:
1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3.
ENGRAVE P/N USING 0.10 HIGH LETTERS TO A MAX. DEPTH OF 0.010
7) WEIGHT: 0.20 lbs
8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	RF	13.09.16

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	HS	DRAWING NO. D4871 REV. A
MFG. APPR.	JLM	SHEET 1 OF 2
APPROVED	HS	TITLE END FITTING SCALE NTS
DE APPR.	DS	
DATE	13.12.09	

COPYRIGHT © 2013 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO23860

Purchase Order Date 4/17/2014
PO Print Date 4/22/2014

Order From : VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name		**Buyer**	Chantal Lavoie
Vendor Phone	613-446-4544	**Customer POID**	
		Customer Tax #	10127-2607
Ship To Contact		**Terms**	Net 30
Ship To Phone		**Currency**	CAD
Ship Via:	VENDOR'S TRUCK	**FOB**	FCA – (Free Carrier)
Ship Acct:			

Line Total: **$580.00**

9	D4871-1P	End Fitting	5/19/2014 Yes 5/19/2014	FN	8.00 Each	V 10/9/4/5	$145.00	$1,160.00

MACHINE AS PER DWG D4871 REV. A
B116540
MATERIAL: 174PH-H900R1.500 M127334

Line Total: **$1,160.00**

10	D4920-1P	End Fitting	5/19/2014 Yes 5/19/2014	FN	4.00 Each		$145.00	$580.00

MACHINE AS PER DWG D4920 REV. A
B116542
MATERIAL: 174PH-H900R1.500 M128809

Line Total: **$580.00**

Note:

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 908035 Date: 06-Jun-14

To

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613 632-9577 Fax: 613 632-1053

Ship To

CHANTAL LAVOIE
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613 632-9577 Fax: 613 632-1053

Terms	Ship Via

Quantity	Description
	PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.
8 ea	Part: D4871-3P Rev: A END FITTING Job: 16216 PO: PO23860 Line: 5
8 ea	Part: D4871-1P Rev: A END FITTING Job: 16220 PO: PO23860 Line: 9
	DATE: 06 June 2014 CERTIFIED SIGNATURE: [signature] RECEIVER SIGNATURE : [signature] CERTIFICATE OF CONFORMANCE. A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT ARE IN CONFORMANCE WITH THE REQUIREMENTS, SPECIFICATIONS, AND DRAWINGS REFERENCED IN THE ABOVE PURCHASE ORDER. I.S.O. 9001 : 2008 REGISTERED / MADE IN CANADA

First Article Inspection Report

ATG INDUSTRIES INC.

731 Industrielle St
Rockland, Ontario K4K 1T2
Ph: 613 446-4544

Customer:	Dart Aerospace	Date:	June 13th, 2014	506
Part Number:	D4871-1P	Revision:	A	
PO Number:	PO23860	Qty:	8	FAI No.

Item	Dimension	Measurement Inspected by: Rene Tougas, Q.C.	Remarks
1	2.75	2.747	Section A-A
2	1.579±.005	1.549	
3	1.10	1.101	
4	R.06	✓	
5	.500	.499	
6	.43	.432	
7	.030	.028	
8	.017	.018	
9	Ø.500	.501	
10	.400	.398	
11	1.51	1.505	
12	.751	.750	
13	.09 REF	.120 DRILL POINT	
14	R.13	✓	
15	.30	.300	
16	.083	.083	
17	50.1º	✓	
18	.375	.373	
19	R.50	✓	
20	Ø.250/.249	.2495	Auxiliary view B-B
21	.376 REF	.379	
22	.93	.929	
23	.10	.100	Auxiliary view E-E
24	Note 6	✓	
25	R.031	✓	
26	Ø.670+.000/-.001	.6699	
27	1.41	1.412	
28	Ø.85 x 150º	Ø.85 x 150º	
29	.20 x 45º Chamfer	.225	2 Places
30	.40	.400	
31	.090 TYP	.091	
32	.75	.750	

First Article Inspection Report

731 Industrielle St
Rockland, Ontario K4K 1T2
Ph: 613 446-4544

Customer:	Dart Aerospace	Date:	June 13th, 2014	506
Part Number:	D4871-1P	Revision:	A	
PO Number:	PO23860	Qty:	8	FAI No.

Item	Dimension	Measurement Inspected by: Rene Tougas, Q.C.	Remarks
33	25.4º	25.4º	Section C-C
34	Ø.125 thru	Ø.125	
35	34.6º	34.6º	Section D-D
36	Ø.125 thru	Ø.125	
37	Material:	17-4SS H900 1.50" RD BAR	Supplied by Customer
38	Treatment:	Liquid Penetrant	PO#:20140212

skyservice Work Order Traveler

Sky Service F.B.O. Inc.

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO21093	**Customer:** ATG Industries Inc	**Dept:** NDT YUL	**Reference:** 20140212
Descr:	**PN:**	**S/N:**	**Qty:** 1
Make:	**Model:**	**Reg:**	**A/C S/N:**
TSN: 0	**CSN:** 0	**TSO:** 0	

Task: UNSCHEDULED | **Sequence:** 1

Work Required:

CARRY OUT NDT ON 16 PARTS AS PER PO: 20140212

Action Taken:	Date:	Initial/Stamp:
LPI C/O AS PER ASTM E-1417M-13 NO CRACK FOUND PEN.(ZL-37 , B#10A070), CLEAN(SKC-S,B#09F21K),DEV.(SKD-S2,B#09L04K) EMU.(ZR-10B,B#10A074).	JUN 04 2014	DAS 27 3-89 4/6/9 DOT · APP 26 53-89

Description	*Location*	*P/N*	*Qty*	*Batch*	*S/N Off*	*S/N On*

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	**ACA/SCA Stamp**	Date:
Name: KARIK MELIKIAN	DOT · APP 20 53-89	JUN 04 2014